

Date: Tuesday, 03/02/2009 8:19:54 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 45435		
Estimate Number	: 12781		
P.O. Number	:	Part Number	: D35641
This Issue	: 03/02/2009 S.O. No. :	Drawing Number	: D3564 REVD
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 45433	Material	:
Written By	:	Due Date	: 10/02/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>MF 09-02-03</u>		
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 1.1550 sf(s)/Unit Total : 13.8600 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 110551 1B 9-2-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: B 1B 9-2-3
 Prog Rev: B
 2-Deburr if necessary 1B 9-2-3



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/02/04 (13)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary 1/8
 Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155

EP 09/02/05 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 45435

Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

SB 09/02/06 (13)

S 09/02/06 (X13)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat

M109893

Weld hardcoat as per Dwg D3437

EL 9-2-9 X13

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/09 (X13)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/09 (X13)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
320°
10:45

BR 09-02-12

(13)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/02/12 (13)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-19

BR 09-02-12

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13 *MF*

Job Completion



MF 09-02-12

DART AEROSPACE LTD		Work Order:	45435
Description: Wearshoe		Part Number:	D3564-1
Inspection Dwg: D3564	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.222	X			
2.432	+/-0.010	2.433	X			
2.50	+/-0.030	2.503	X			
6.000	+/-0.010	5.994	X			
12.104	+/-0.010	12.100	X			
18.000	+/-0.010	18.000	X			
18.00	+/-0.030	18.00	X			
9.00	+/-0.030	9.00	X			
11.50	+/-0.030	11.50	X			
0.300 x 0.300	+/-0.010	304 X 305	X			
Ø0.188	+0.005/-0.001	.191	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-3	Date: 09/02/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	FE

